



Dart Aerospace Ltd.
1270 Aberdeen St
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D135-692-041
Job Sheet 196625



Part No: D135-692-041

Job Qty: 2 pcs ✓

Part Name: EC135 Bearpaw Wearplates



Part Weight: 0 lbs

Job Created: 6/17/19

Due Date: 7/26/19

Type: Stock

Status: New

Job Tracking No:

Created By: Marie Lajeunesse

Description: SIGP

Priority: Medium

Note: DWG DSI9400 REV A, DSI9750 REV A IPP Rev:A new issue ECN1089 08-02-04 DD verified by:EC IPP
Rev:B ECN 1132 08-02-20 DD verified by:EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard Setup Hrs	Run Hrs	Workcenter/Supplier	Sign-off
110	Packaging 1 - Pick Kit	2 pcs		7/26/19	0.00	0.00	Packaging 1 - 1	
							Packaging 1 - 2	
							Packaging 1 - 3 ✓	
							Packaging 1 - 4	
							Packaging 1 - 5	
							Packaging 1 - 6	
							Packaging 1 - 7	
							Packaging 1 - 8	
							Packaging 1 - 9	
							Packaging 1 - 10	
							Packaging 1 - 11	
							Packaging 1 - 12	
							Packaging 1 - 13	
							Packaging 1 - 14	
							Packaging 1 - 15	
							Packaging 1 - 16	
							Packaging 1 - 17	
							Packaging 1 - 18	
							Packaging 1 - 19	
							Packaging 1 - 20	
							Packaging 1 - 21	
							Packaging 1 - 22	
							Packaging 1 - 23	
							Packaging 1 - 24	
							Packaging 1 - 25	
							Packaging 1 - 26	
							Packaging 1 - 27	
							Packaging 1 - 28	
							Packaging 1 - 29	
							Packaging 1 - 30	



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Container No: S215282



Part: D135-692-041

Job No: 196625

Serial No/Batch: S215282

Revision:

Inspector:

Exp Date:

Instructions: FAA STC SR01042SE 18/10/17, TC LoA 120S-

6/17/2019

[Dart Hawkesbury] Job Sheet - Lajeunesse, Marie

120 QC 4	2 pcs	7/26/19	0.00 0.00	Packaging 1 - 31		
				Packaging 1 - 32		
				Packaging 1 - 33		
				Packaging 1 - 34		
				Packaging 1 - 35		
				Packaging 1 - 36		
				QC 4 - 28		
				QC 4 - 58		
				QC 4 - 69		
				QC 4 - 9		
				QC 4 - 46		
				QC 4 - 68		
				QC 4 - 72		
				QC 4 - 74		
130 Packaging 3-1 - Stock - B4B 2 pcs		7/26/19	0.00 0.00	QC 4 - 75		
				Packaging 3 - 1 - B4B		
				Packaging 3 - 2 - B4B		
				Packaging 3 - 3 - B4B		
				Packaging 3 - 4 - B4B		
				Packaging 3 - 5 - B4B		
				Packaging 3 - 6 - B4B		
				Packaging 3 - 7 - B4B		
				Packaging 3 - 8 - B4B		
				Packaging 3 - 9 - B4B		
				Packaging 3 - 10 - B4B		
				Packaging 3 - 11 - B4B		
				Packaging 3 - 12 - B4B		
				Packaging 3 - 13 - B4B		
				Packaging 3 - 14 - B4B		
				Packaging 3 - 15 - B4B		
				Packaging 3 - 16 - B4B		
				Packaging 3 - 17 - B4B		
				Packaging 3 - 18 - B4B		
				Packaging 3 - 19 - B4B		
				Packaging 3 - 20 - B4B		
				Packaging 3 - 21 - B4B		
				Packaging 3 - 22 - B4B		
				Packaging 3 - 23 - B4B		
				Packaging 3 - 24 - B4B		
				Packaging 3 - 25 - B4B		
				Packaging 3 - 26 - B4B		
				Packaging 3 - 27 - B4B		
				Packaging 3 - 28 - B4B		
				Packaging 3 - 29 - B4B		
				Packaging 3 - 30 - B4B		
				Packaging 3 - 31 - B4B		
				Packaging 3 - 32 - B4B		
				Packaging 3 - 33 - B4B		
				Packaging 3 - 34 - B4B		
				Packaging 3 - 35 - B4B		
				Packaging 3 - 36 - B4B		
135 DC - 1 - B4B	2 pcs	7/26/19	0.00 0.00	DC - 1 - B4B		
140 QC 21 - FG	2 pcs	7/26/19	0.00 0.00	DC - 2 - B4B		
				QC 21 - FG - 21		
				QC 21 - FG - 70		
				QC 21 - SA - 53		

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FG013

Part Op 110 - (Pick Kit)
 Descriptions: 120 - (QC4- 100% Inspect kits for completeness)
 130 - Identify and pack for shipping as per PPP D135-692-041 CHG001 PPP Rev:

8/17/2019

[Dart Hawkesbury] Job Sheet - Lajeunesse, Marie

135 - (Document Control) Photocopy bluefile and create labels per PPP D135-692-041 CHG002

140 - (QC21- Final Inspection - Work Order Release)

Master Unit No 010711

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
AN4-11A ST344	Bolt	8 Ea (4 ea) ✓	110-Packaging 1 - Pick Kit	5179658 ✓
AN4-13A ST344	Bolt	16 Ea (8 ea) ✓	110-Packaging 1 - Pick Kit	5179658 ✓
D2529 ST008	Washer	16 pcs (8 ea) ✓	110-Packaging 1 - Pick Kit	5179658 ✓
D3719-041	Wearplate Assembly	4 pcs (2 ea) ✓	110-Packaging 1 - Pick Kit	5179658 ✓
MS21042L4 ST303	Nut	24 Ea (12 ea) ✓	110-Packaging 1 - Pick Kit	5179658 ✓
NAS1149D0463J 51264	Washer	16 Ea (8 ea) ✓	110-Packaging 1 - Pick Kit	5179658 ✓

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
110-Packaging 1 - Pick Kit	AN4-11A	8	114	0
	AN4-13A	16	594	0
	D2529	16	556	0
	D3719-041	4	0	0
	MS21042L4	24	1,792	0
	NAS1149D0463J	16	2,796	0

Part Specifications

Specifications could not be found.

Plex 6/17/19 2:44 PM Dart.lajeunesse.marie

Entered:

Date:

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No.

Route update only



Job: _____ Part No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐		DEPARTMENT/PROCESS Skid-tube ☐ Cross tube ☐ Machining ☐ Small Fab ☐ Large Fab ☐ Finishing ☐		Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐																													
Date :		Sequence #:		QTY Affected :		MRB (QSI042)																													
Description Work Order Deviation				Disposition																															
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐				FAULT CATEGORY <table border="1"> <tr> <td>Pressure/Forced</td> <td>Contamination</td> <td>Power Loss/Surge</td> <td>Positioned Wrong</td> </tr> <tr> <td>Bending</td> <td>Misaligned/off center</td> <td>Folio/Program</td> <td>Outside Tolerance</td> </tr> <tr> <td>Crushing</td> <td>BOM/Route</td> <td>Grain Direction</td> <td>Drawing</td> </tr> <tr> <td>Cracks</td> <td>Broken/Damage/Defect</td> <td>Weld</td> <td>Finish</td> </tr> <tr> <td>Crimp/Kink/Ripple/Wave/Twist</td> <td>Incomplete/Unclear Instructions</td> <td>Wrong Stock Pulled</td> <td>Part Lost/Missing</td> </tr> <tr> <td>Marks/Chatter</td> <td>Drill Holes</td> <td>Out of Sequence</td> <td>Misread</td> </tr> <tr> <td>Mislabeled</td> <td>Fit/Function</td> <td>Off-set/Set-up</td> <td></td> </tr> </table>				Pressure/Forced	Contamination	Power Loss/Surge	Positioned Wrong	Bending	Misaligned/off center	Folio/Program	Outside Tolerance	Crushing	BOM/Route	Grain Direction	Drawing	Cracks	Broken/Damage/Defect	Weld	Finish	Crimp/Kink/Ripple/Wave/Twist	Incomplete/Unclear Instructions	Wrong Stock Pulled	Part Lost/Missing	Marks/Chatter	Drill Holes	Out of Sequence	Misread	Mislabeled	Fit/Function	Off-set/Set-up	
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Mislabeled	Fit/Function	Off-set/Set-up																																	
Other/Details:																																			
Completed By				Lead hand / Supervisor																															
				QC / QA Coordinator																															

4. WEIGHT AND BALANCE

Installation	Weight	LATERAL		LONGITUDINAL	
		Arm	Moment	Arm	Moment
D135-692-011	11.8 lb	0.0 in	0.0 in-lb	199.7 in	2356 in-lb
<i>Bearpaw Installation</i>	5.36 kg	0.0 m	0.0 m-kg	5.07 m	27.2 m-kg
D135-692-041	2.24 lb	0.0 in	0.0 in-lb	199.7 in	447 in-lb
<i>Wearplate Kit</i>	1.0 kg	0.0 m	0.0 m-kg	5.07 m	5.1 m-kg
D135-692-011	11.8 lb	0.0 in	0.0 in-lb	201 in	2372 in-lb
<i>Bearpaw Installation, Aft Location</i>	5.36 kg	0.0 m	0.0 m-kg	5.10 m	27.3 m-kg
D135-692-041	2.24 lb	0.0 in	0.0 in-lb	201 in	450 in-lb
<i>Wearplate Kit, Aft Location</i>	1.0 kg	0.0 m	0.0 m-kg	5.10 m	5.1 m-kg

5. PARTS LIST

Qty -011	Qty -041	Part Number	Description
X		D135-692-011	BEARPAW INSTALLATION
	X	D135-692-041	WEARPLATE KIT
4		D2182B060	RUBBER CUSHION
8		D2274	RADIUS BLOCK
2		D3049-1	BEARPAW
8		D2529	WASHER
4		D2519	CLAMP
	2	D3719-041	WEARPLATE
8	8	AN4-13A	BOLT
8	8	NAS1149D0463J	WASHERS
8	8	MS21042L4	NUT (OR MS21042-4)
4		QS100M24S	CLAMP